

Date: Thursday, 2/14/2008 10:57:53 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LUG BRACKET		
Job Number	37437			Part Number	D27351		
Estimate Number	10009			Drawing Number	D2735 REV C		
P.O. Number	:			Project Number	N/A		
This Issue	2/14/2008	S.O. No.	:	Drawing Revision	C		
Prsht Rev.	NC			Material	:		
First Issue	/ /			Due Date	3/10/2008	Qty:	12
Previous Run	34830			Um:	Each		
Written By	<u>HB 08 02 14</u>			JLM			
Checked & Approved By				EC			
Comment	Est Rev:C Removed from 9 Digit est rev D waterjet			05-10-25 06.09.19			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125
Comment: Qty.: 0.1733 sf(s)/Unit Total : 2.0790 sf(s) 1010-1025 sheet .125 batch: <u>106140</u> <u>HB 8-2-21</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2735 (D2735-1) Dwg Rev: <u>C</u> <u>HB 8-2-21</u> Prog Rev: <u>C</u>		
2-Deburr if necessary <u>HB 8-2-21</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-2-21</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>J2602-25</u> <u>15</u> <u>comptel</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 2-Deburr if required. <u>SB 08/03/12</u> <u>15</u>		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 08/03/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Drawing Name: LUG BRACKET

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



5 08/03/12 (15)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Steve

PC 8/3/13 (15)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

1 Do 03/14

Job Completion



~ 2008/3/13 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37437
Description: Lug Bracket	Part Number:	D2735-1
Inspection Dwg: D2735	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>AB</u>	Audited by: <u> </u>	Prototype Approval: N/A
Date: 8-2-21	Date: 08/2/25	Date: N/A

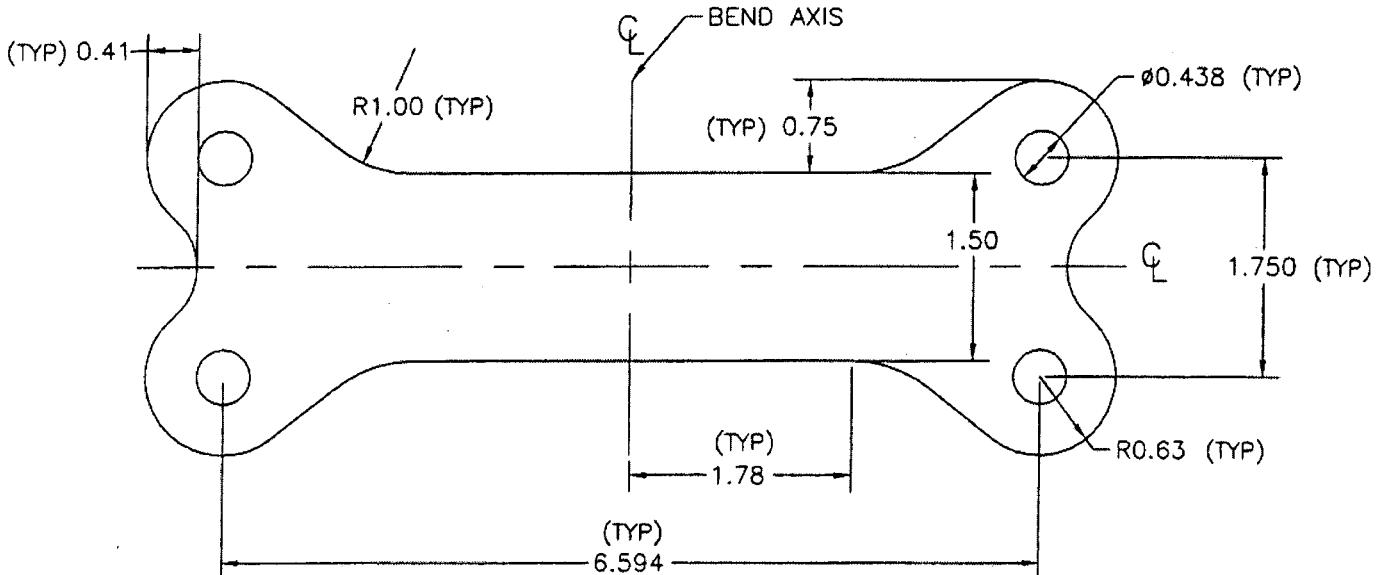
Rev	Date	Change	Revised by	Approved
A	07.02.02	New Issue	KJ/JLM	<i>[Signature]</i>

DART

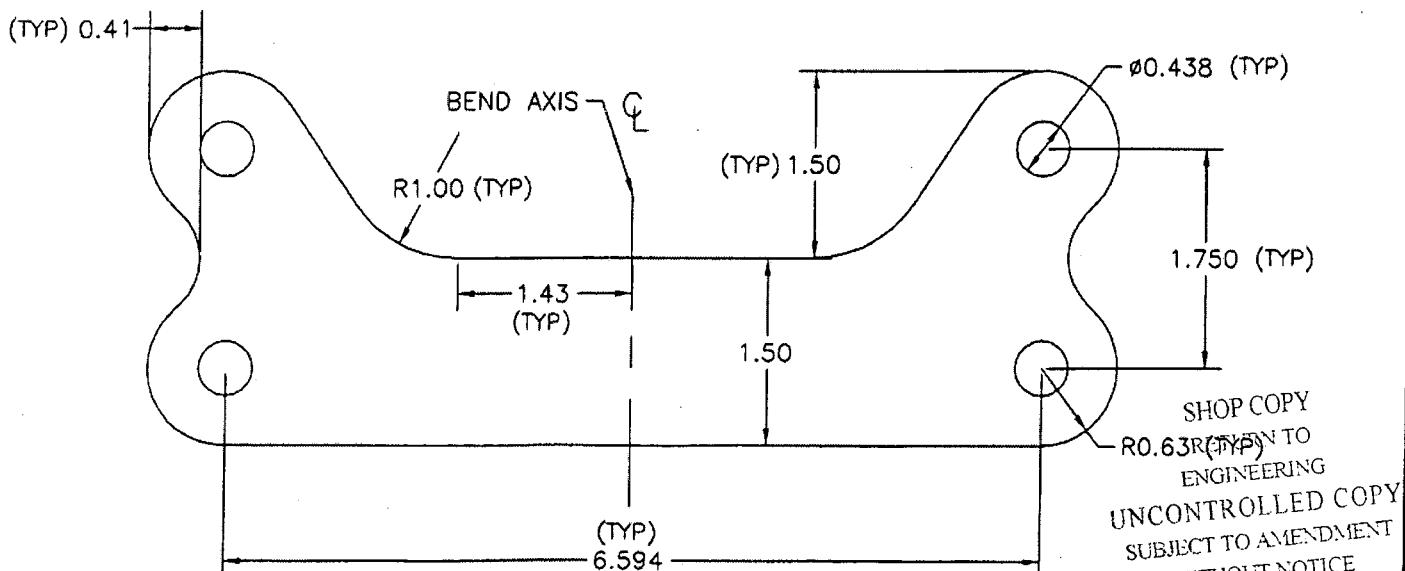
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
CP	KE	D2735	SHEET 1 OF 2
DATE		TITLE	SCALE
98.12.14		LUG BRACKET	2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)

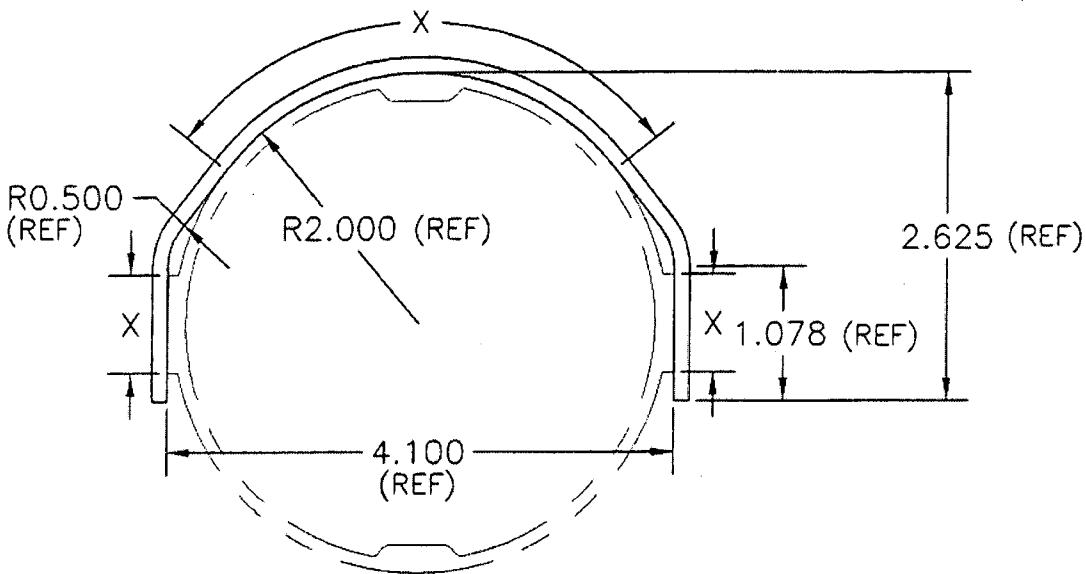


D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (C)



DESIGN <i>SP</i>	DRAWN BY <i>JK</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>SP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37437*